

Polyphenylene Sulfide (PPS)

DURAFIDE®

6565A6

HF2000/HD9050

GF and Mineral
Reinforced

General Properties of 6565A6

table1-1 General Properties (ISO)

Item	Unit	Test Method	GF and Mineral Reinforced
			6565A6
			Moldable at Low Mold Temperature, Adhesion-enhanced
Color			HF2000/HD9050
ISO(JIS)quality-of-the-material display:		ISO11469 (JIS K6999)	>PPS-(GF+MD)65<
Density	g/cm³	ISO 1183	1.96
Water absorption (23°C,24hrs,1mmt)	%	ISO 62	0.01
Melt viscosity (310°C,1000/sec)	Pa·s	ISO 11443	280
Tensile strength	MPa	ISO 527-1,2	125
Strain at break	%	ISO 527-1,2	1.0
Flexural strength	MPa	ISO 178	185
Flexural modulus	MPa	ISO 178	21,000
Charpy notched impact strength (23°C)	kJ/m²	ISO 179/1eA	6.0
Temperature of deflection under load (1.8MPa)	°C	ISO 75-1,2	275
Coefficient of linear thermal expansion (Normal temperature, Flow direction)	x10 ⁻⁵ /°C	Our standard	1
Coefficient of linear thermal expansion (Normal temperature, Transverse direction)	x10 ⁻⁵ /°C	Our standard	3
Electric strength (3mmt)	kV/mm	IEC 60243-1	16
Volume resistivity	Ω·cm	IEC 60093	2 × 10 ¹⁶
Volume resistivity (Our standard)	Ω·cm		-
Relative permittivity (1kHz)		IEC 60250	5.4
Relative permittivity (1MHz)		IEC 60250	5.4
Dielectric dissipation factor (1kHz)		IEC 60250	0.013
Dielectric dissipation factor (1MHz)		IEC 60250	0.005
Tracking resistance (CTI)	V	IEC 60112	225
Arc resistance	s	ASTM D495	189
Rockwell hardness	M(Scale)	ISO2039-2	95
Flammability		UL94	V-0
The yellow card File No.			E109088
Appropriate List number of Ministerial Ordinance for Export Trade Control			Item 16 of Appendix -1

All figures in the table are the typical values of the material and not the minimum values of the material specifications.

1. Characteristics

- **6565A6** is glass fiber and mineral reinforced grade.
- **6565A6** can be molded on low temperature molds, and has high adhesion property with epoxy-based adhesives.

2. Thermal Properties

2-1) Coefficient of Linear Thermal Expansion

(Table 2-1) Coefficient of Linear Thermal Expansion

Unit: $\times 10^{-5}/^{\circ}\text{C}$

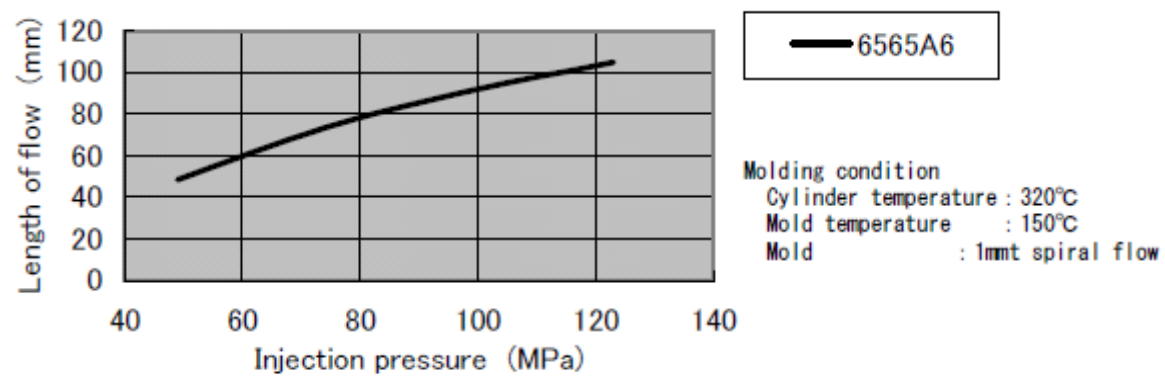
Grade		6565A6	
Direction		Flow direction	Transverse direction
Temperature ($^{\circ}\text{C}$)	-30	1.1	2.2
	0	1.1	2.4
	50	1.2	2.5
	100	1.2	3.0
	150	1.3	4.0
	200	1.2	3.9

Standard temperature: 20°C

3. Molding Properties

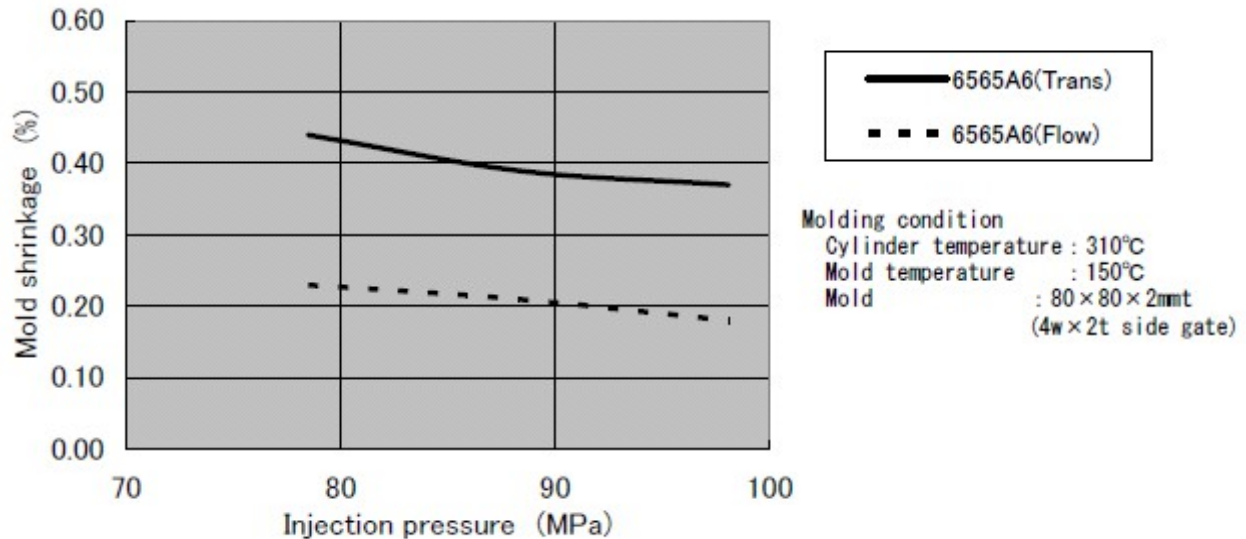
3-1) Flowability

(Figure 3-1) Flowability (1 mmt)



3-2) Mold Shrinkage

(Figure 3-2) Mold Shrinkage (80□×2mmt)

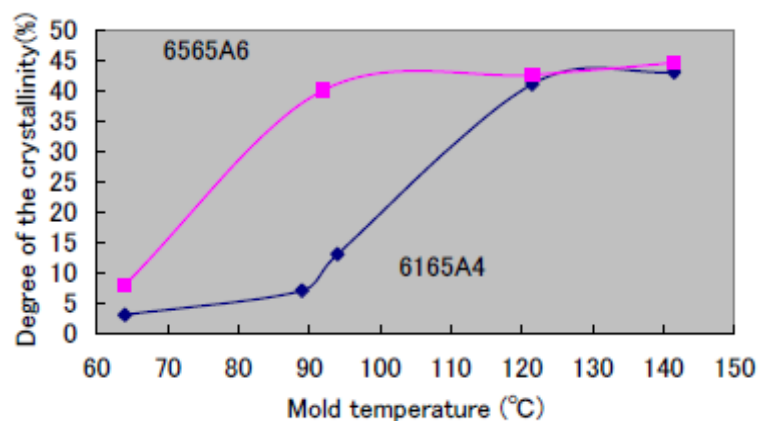


3-3) Mold Temperature

Because PPS is crystalline resin, it is necessary to crystallize sufficiently for excellent properties, so the crystalline resin is molded the mold temperature more than T_g . However the T_g of PPS is about 90°C, the mold temperature needs to mold PPS more than 130°C.

Figure 3-3 shows the relationship between the mold temperature and the degree of the crystallinity.

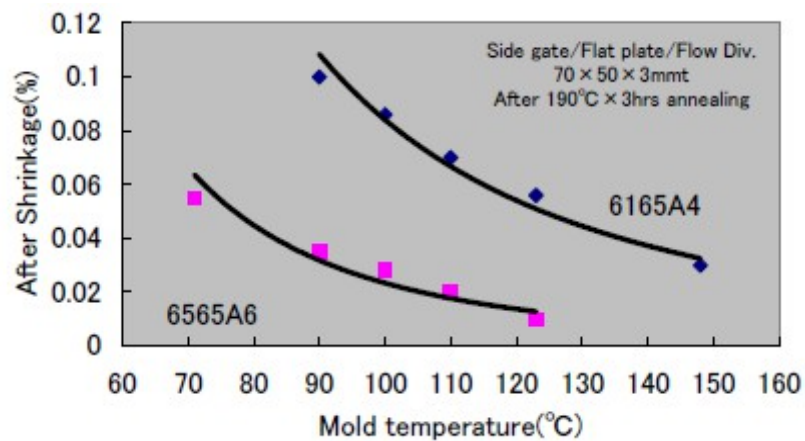
(Figure 3-3) Mold Temperature vs. Degree of the Crystallinity



3-4) After Shrinkage

Figure 3-4 shows the relationship between the mold temperature and after shrinkage. The after shrinkage of **6565A6** at 100°C is almost same as that of **6165A4** at 150°C, so the after shrinkage of **6565A6** is same as that of 6165A4.

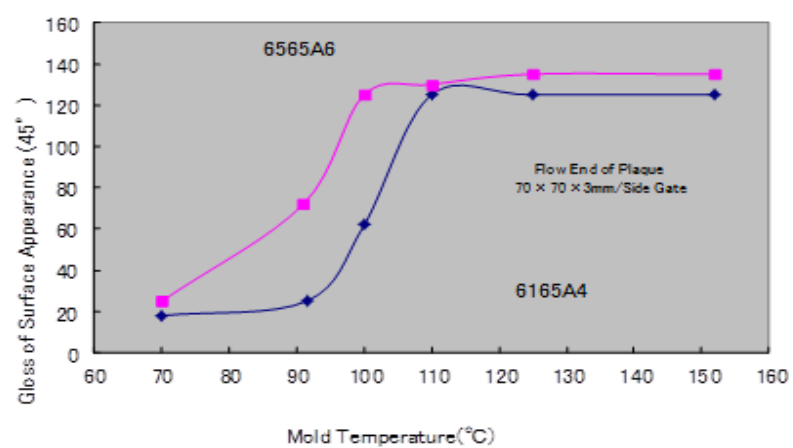
(Figure 3-4) Mold Temperature vs. After Shrinkage



3-5) Surface Appearance

The surface appearance for **6565A6** can be acquired at 100°C.

(Figure 3-5) Surface Appearance vs. Mold Temperature



NOTES TO USERS

- All property values shown in this brochure are the typical values obtained under conditions prescribed by applicable standards and test methods.
- This brochure has been prepared based on our own experiences and laboratory test data, and therefore all data shown here are not always applicable to parts used under different conditions. We do not guarantee that these data are directly applicable to the application conditions of users and we ask each user to make his own decision on the application.
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- For all works done properly, it is advised to refer to appropriate technical catalogs for specific material processing.
- For safe handling of materials we supply, it is advised to refer to the Safety Data Sheet "SDS" of the proper material.
- This brochure is edited based on reference literature, information and data available to us at the time of creation. The contents of this brochure are subject to change without notice upon achievement of new data.
- Please contact our office for any questions about products we supply, descriptive literatures or any description in this brochure.

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